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**D4634-141**  
**Job Sheet 199079**

**Part No:** D4634-141      **Job Qty:** 1 pcs  
**Part Name:** Fwd, Center Ceiling Replacement Panel Assembly



**Part Weight:** 0 lbs      **Status:** New      **Priority:** Medium  
**Job Created:** 8/12/19      **Job Tracking No:**  
**Due Date:** 9/20/19      **Created By:** Marie Lajeunesse  
**Type:** SOLD      **Description:**

**Note:** DWG D4634 REV.H SHEET 7 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Document release DL  
VERIFIED BY:JLM IPP Rev C 13/07/09 Dwg Update DL verf: DD IPP Rev D Dwg Update 13/12/23 DL IPP  
REV E Dwg update 14/01/09 DL IPP Rev F Dwg. update 14/02/03 DL IPP Rev G Dwg. Update 15/01/27 DL

**Ship Via:**

**Bill of Materials**

**Job Routing**

| Op No | Operation                   | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off                      |
|-------|-----------------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|-------------------------------|
|       |                             |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |                               |
| 100   | Small Fab - 1               | 1 pcs | 9/20/19    |          | 0.00      | 1.67    | Small Fab - 1         |           | DAS<br>58 SEP 13 2019<br>9-89 |
|       |                             |       |            |          |           |         | Small Fab - 2         |           |                               |
|       |                             |       |            |          |           |         | Small Fab - 3         |           |                               |
|       |                             |       |            |          |           |         | Small Fab - 4         |           |                               |
|       |                             |       |            |          |           |         | Small Fab - 5         |           |                               |
|       |                             |       |            |          |           |         | Small Fab - 6         |           |                               |
|       |                             |       |            |          |           |         | Small Fab - 7         |           |                               |
|       |                             |       |            |          |           |         | Small Fab - 8         |           |                               |
| 120   | QC 5                        | 1 pcs | 9/20/19    |          | 0.00      | 0.00    | QC 5 - 10             |           | DAS<br>SEP 23 2019<br>9-89    |
|       |                             |       |            |          |           |         | QC 5 - 12             |           |                               |
|       |                             |       |            |          |           |         | QC 5 - 17             |           |                               |
|       |                             |       |            |          |           |         | QC 5 - 18             |           |                               |
|       |                             |       |            |          |           |         | QC 5 - 19             |           |                               |
|       |                             |       |            |          |           |         | QC 5 - 22             |           |                               |
|       |                             |       |            |          |           |         | QC 5 - 24             |           |                               |
|       |                             |       |            |          |           |         | QC 5 - 3              |           |                               |
|       |                             |       |            |          |           |         | QC 5 - 43             |           |                               |
|       |                             |       |            |          |           |         | QC 5 - 49             |           |                               |
|       |                             |       |            |          |           |         | QC 5 - 51             |           |                               |
|       |                             |       |            |          |           |         | QC 5 - 58             |           |                               |
|       |                             |       |            |          |           |         | QC 5 - 68             |           |                               |
|       |                             |       |            |          |           |         | QC 5 - 9              |           |                               |
|       |                             |       |            |          |           |         | QC 5 - 50             |           |                               |
|       |                             |       |            |          |           |         | QC 5 - 30             |           |                               |
|       |                             |       |            |          |           |         | QC 5 - 40             |           |                               |
|       |                             |       |            |          |           |         | QC 5 - 61             |           |                               |
|       |                             |       |            |          |           |         | QC 5 - 81             |           |                               |
| 130   | Packaging 3-1 - Stock - B4B | 1 pcs | 9/20/19    |          | 0.00      | 0.00    | Packaging 3 - 1 - B4B |           |                               |
|       |                             |       |            |          |           |         | Packaging 3 - 2 - B4B |           |                               |
|       |                             |       |            |          |           |         | Packaging 3 - 3 - B4B |           |                               |

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|                |       |         |           |                        |  |
|----------------|-------|---------|-----------|------------------------|--|
|                |       |         |           | Packaging 3 - 4 - B4B  |  |
|                |       |         |           | Packaging 3 - 5 - B4B  |  |
|                |       |         |           | Packaging 3 - 6 - B4B  |  |
|                |       |         |           | Packaging 3 - 7 - B4B  |  |
|                |       |         |           | Packaging 3 - 8 - B4B  |  |
|                |       |         |           | Packaging 3 - 9 - B4B  |  |
|                |       |         |           | Packaging 3 - 10 - B4B |  |
|                |       |         |           | Packaging 3 - 11 - B4B |  |
|                |       |         |           | Packaging 3 - 12 - B4B |  |
|                |       |         |           | Packaging 3 - 13 - B4B |  |
|                |       |         |           | Packaging 3 - 14 - B4B |  |
|                |       |         |           | Packaging 3 - 15 - B4B |  |
|                |       |         |           | Packaging 3 - 16 - B4B |  |
|                |       |         |           | Packaging 3 - 17 - B4B |  |
|                |       |         |           | Packaging 3 - 18 - B4B |  |
|                |       |         |           | Packaging 3 - 19 - B4B |  |
|                |       |         |           | Packaging 3 - 20 - B4B |  |
|                |       |         |           | Packaging 3 - 21 - B4B |  |
|                |       |         |           | Packaging 3 - 22 - B4B |  |
|                |       |         |           | Packaging 3 - 23 - B4B |  |
|                |       |         |           | Packaging 3 - 24 - B4B |  |
|                |       |         |           | Packaging 3 - 25 - B4B |  |
|                |       |         |           | Packaging 3 - 26 - B4B |  |
|                |       |         |           | Packaging 3 - 27 - B4B |  |
|                |       |         |           | Packaging 3 - 28 - B4B |  |
|                |       |         |           | Packaging 3 - 29 - B4B |  |
|                |       |         |           | Packaging 3 - 30 - B4B |  |
|                |       |         |           | Packaging 3 - 31 - B4B |  |
|                |       |         |           | Packaging 3 - 32 - B4B |  |
|                |       |         |           | Packaging 3 - 33 - B4B |  |
|                |       |         |           | Packaging 3 - 34 - B4B |  |
|                |       |         |           | Packaging 3 - 35 - B4B |  |
|                |       |         |           | Packaging 3 - 36 - B4B |  |
| 140 QC 21 - SA | 1 pcs | 9/20/19 | 0.00 0.00 | QC 21 - SA - 21        |  |
|                |       |         |           | QC 21 - SA - 70        |  |
|                |       |         |           | QC 21 - SA - 53        |  |

Part Op **100** - Small Fab (Small Fab) Assemble as per Dwg D4634-141 Bond foam core to inside of panel 3M Scotch Weld 1300  
 Descriptions: Batch: 521467 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with  
 wash & wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II. (see  
 note 8) Batch # 5159491 Expiry Date 02/07/2008 3- Apply labels as per Dwg. and seal with 3M  
 3950 edge sealer (see note 9) Batch: m138941  
**120** - QC5 (QC5- Inspect part completeness to step on W/O) QC5- Inspect part completeness to step on W/O  
**130** - Packaging3 (Identify as per dwg & Stock Location:         ) Identify as per dwg & Stock Location: CA  
**140** - QC21 (QC21- Final Inspection - Work Order Release) QC21- Final Inspection - Work Order Release

### Job BOM

| Part / Item   | Component Name            | Quantity     | Operation         | Container |
|---------------|---------------------------|--------------|-------------------|-----------|
| CCR264SS-3-03 | Cherry Rivet              | 4 Ea (4 ea)  | 100-Small Fab - 1 | S180315   |
| D4634-1       | Fwd, Center Ceiling Panel | 1 pcs (1 ea) | 100-Small Fab - 1 | S131019   |
| D4636-5       | Bracket                   | 1 pcs (1 ea) | 100-Small Fab - 1 | S033775   |
| D4647-5       | Doubler                   | 1 pcs (1 ea) | 100-Small Fab - 1 | S033885   |
| D4664-5       | Spacer                    | 6 pcs (6 ea) | 100-Small Fab - 1 | S130125   |
| D4712-1       | Bracket                   | 1 pcs (1 ea) | 100-Small Fab - 1 | S033885   |
| D4732-15      | Label                     | 1 pcs (1 ea) | 100-Small Fab - 1 | S008991   |
| D4732-19      | Label                     | 1 pcs (1 ea) | 100-Small Fab - 1 | S008905   |
| D5021-1       | Foam, Center Panel, Fwd   | 1 pcs (1 ea) | 100-Small Fab - 1 | S012338   |
| MPNY-750S-9-C | Mounting Pad              | 7 pcs (7 ea) | 100-Small Fab - 1 | S0337162  |
| MS20426AD4-6  | Rivet                     | 2 Ea (2 ea)  | 100-Small Fab - 1 | S093088-1 |
| MS21059L08    | Nut                       | 2 Ea (2 ea)  | 100-Small Fab - 1 | S140391   |

| Job Allocations                    |                |          |           |           |
|------------------------------------|----------------|----------|-----------|-----------|
| Operation                          | Component Part | Required | Inventory | Allocated |
| 100-Small Fab - 1                  | CCR264SS-3-03  | 4        | 224       | 0         |
|                                    | D4634-1        | 1        | 2         | 0         |
|                                    | D4636-5        | 1        | 42        | 0         |
|                                    | D4647-5        | 1        | 14        | 0         |
|                                    | D4664-5        | 6        | 13        | 0         |
|                                    | D4712-1        | 1        | 2         | 0         |
|                                    | D4732-15       | 1        | 4         | 0         |
|                                    | D4732-19       | 1        | 11        | 0         |
|                                    | D5021-1        | 1        | 0         | 0         |
|                                    | MPNY-750S-9-C  | 7        | 111       | 0         |
|                                    | MS20426AD4-6   | 2        | 793       | 0         |
|                                    | MS21059L08     | 2        | 152       | 0         |
| Part Specifications                |                |          |           |           |
| Specifications could not be found. |                |          |           |           |

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Entered: \_\_\_\_\_ Date: \_\_\_\_\_

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



Route update only ☐

NCR No. \_\_\_\_\_

|                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |                              |  |  |  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------------|--|--|--|
| Job: _____<br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                               |                   | <b>DISPOSITION</b><br><div><input type="checkbox"/> Rework<br/><input type="checkbox"/> Scrap<br/><input type="checkbox"/> Use-as-is</div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |  | <b>DEPARTMENT/PROCESS</b><br><div><div>Skid-tube <input type="checkbox"/><br/>Machining <input type="checkbox"/><br/>Large Fab <input type="checkbox"/></div><div>Cross tube <input type="checkbox"/><br/>Small Fab <input type="checkbox"/><br/>Finishing <input type="checkbox"/></div><div>Eng. (Non-AW) <input type="checkbox"/><br/>Prod. Eng. Coord. <input type="checkbox"/><br/>Rec/Store/Packaging <input type="checkbox"/></div><div>Engineering <input type="checkbox"/><br/>Water Jet <input type="checkbox"/><br/>Supplier <input type="checkbox"/><br/>Quality <input type="checkbox"/></div></div> |  |                              |  |  |  |
| Date: _____                                                                                                                                                                                                                                                                                                                                                                                                                                                | Sequence #: _____ | QTY Affected: _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |  | MRB (QS1042)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  |                              |  |  |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                           |                   | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |                              |  |  |  |
| <b>Root Cause</b><br><div><div>Operator <input type="checkbox"/></div><div>Manufacturing Process <input type="checkbox"/></div><div>Equip/Tooling <input type="checkbox"/></div><div>Handling/Preservation <input type="checkbox"/></div><div>Material <input type="checkbox"/></div><div>Product Improvement <input type="checkbox"/></div><div>Process Improvement <input type="checkbox"/></div><div>Human Factors <input type="checkbox"/></div></div> |                   | <b>FAULT CATEGORY</b><br><div><div>Pressure/Forced <input type="checkbox"/></div><div>Bending <input type="checkbox"/></div><div>Crushing <input type="checkbox"/></div><div>Cracks <input type="checkbox"/></div><div>Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/></div><div>Marks/Chatter <input type="checkbox"/></div><div>Mislabeled <input type="checkbox"/></div><div>Other/Details: _____</div></div> <div><div>Contamination <input type="checkbox"/></div><div>Misaligned/off center <input type="checkbox"/></div><div>BOM/Route <input type="checkbox"/></div><div>Broken/Damage/Defect <input type="checkbox"/></div><div>Incomplete/Unclear Instructions <input type="checkbox"/></div><div>Drill Holes <input type="checkbox"/></div><div>Fit/Function <input type="checkbox"/></div></div> <div><div>Power Loss/Surge <input type="checkbox"/></div><div>Folio/Program <input type="checkbox"/></div><div>Grain Direction <input type="checkbox"/></div><div>Weld <input type="checkbox"/></div><div>Wrong Stock Pulled <input type="checkbox"/></div><div>Out of Sequence <input type="checkbox"/></div><div>Off-set/Set-up <input type="checkbox"/></div></div> <div><div>Positioned Wrong <input type="checkbox"/></div><div>Outside Tolerance <input type="checkbox"/></div><div>Drawing <input type="checkbox"/></div><div>Finish <input type="checkbox"/></div><div>Part Lost/Missing <input type="checkbox"/></div><div>Misread <input type="checkbox"/></div></div> |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |                              |  |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  | Completed By _____           |  |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  | Lead hand / Supervisor _____ |  |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  | QC / QA Coordinator _____    |  |  |  |